

Date: Monday, 1/14/2008 2:37:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET RIB
Job Number	: 36752		
Estimate Number	: 10402		
P.O. Number	:	Part Number	: D31661
This Issue	: 1/14/2008 S.O. No. :	Drawing Number	: D3166 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: A1
Previous Run	: 36692	Material	:
Written By	:	Due Date	: 2/10/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>08 01 15</u>		
Comment	: Est. A 02.08.23 New issue KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 5.2500 f(s)/Unit Total : 63.0000 f(s)

304 SQ Tube.75x.75x.065W

(M304TS0750W065)

Material: 304/316 SS tube 0.065" wall

Batch n106818 XEL8-1-16(24)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut 3/4" x 3/4" square tubing 60.00" long.

EL/ID 8-1-16(24)

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.

EL/ID 8-1-16(24)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)

PD 08-01-22(17)PTD

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

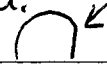

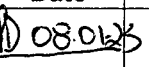

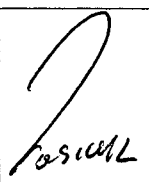

Identify and Stock

Location: WSPD 08-01-22(17)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3166-1 PAR #: N/A Fault Category: Prod / ~~Eng~~ Landing Gear NCR: Yes No DQA: D Date: 08/01/28
 QA: N/C Closed: H Date: 08/01/28

NCR: <u>36752</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-01-23	3.0	7 ribs scrap. Parts were not being formed completely round. They would bend on an angle at the end. RC: Program error 	 Residual	Scrap; no replace. Destroy. Adjust bend program so parts can form to draw. Qty 7 scrap.	 EL 8-1-23	 PD 08-01-23	 Residual	 Residual

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET RIB

Job Number: 36752

Part Number: D31661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.23
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.01.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

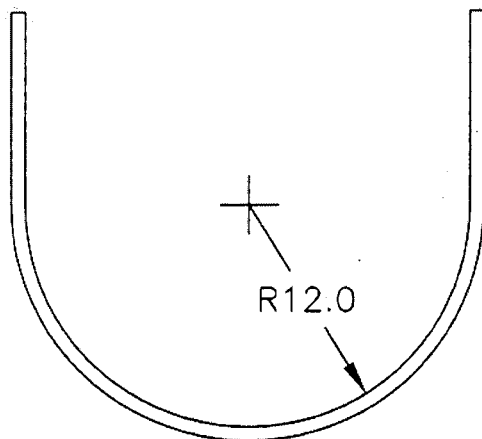
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>#</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 WAS 36.0	

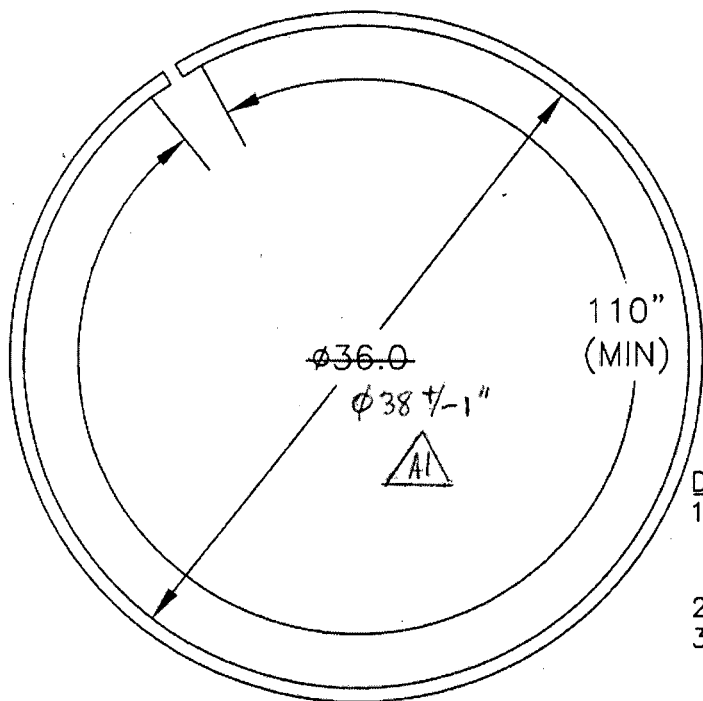
RELEASED
02.08.06 *#*



10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO **36752**

D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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